

Date: Wednesday, 11/03/2009 9:53:21 AM  
User: Chantal Lavoie

Process Sheet

SPLIX

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET
Job Number	: 46413 - 1	Part Number	: D6101013
Estimate Number	: 10036	Drawing Number	: D6101 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 11/03/2009 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 18/09/2009
Previous Run	: 41963	Qty:	50 Um: Each
Written By	:		
Checked & Approved By	: <u>CL09/03/11</u>		
Comment	: Est. A: 01.05.04 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8393

- a) Description: Alluminum billet
- b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000)
- c) Tolerance on all dimensions are +0.030"/-0.000"
- d) Grain direction along 10.100" length
- e) Material: 7075-T7351 (QQ-A-250/12)
- f) Material certification required

CL09/03/13

(50)

2.0	D6101013P	Saddle billet
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Comment: Qty: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)  
Saddle billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

- Receive & Inspect For Transit Damage
- Ensure material certification is attached

10/09/06/10 CL 09/06/10

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

CL09/06/10 (x10)

Date: Wednesday, 11/03/2009 9:53:22 AM  
User: Chantal Laviole

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 46413

Part Number: D6101013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*mf 09/09/04*

*(10)*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/10/05*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



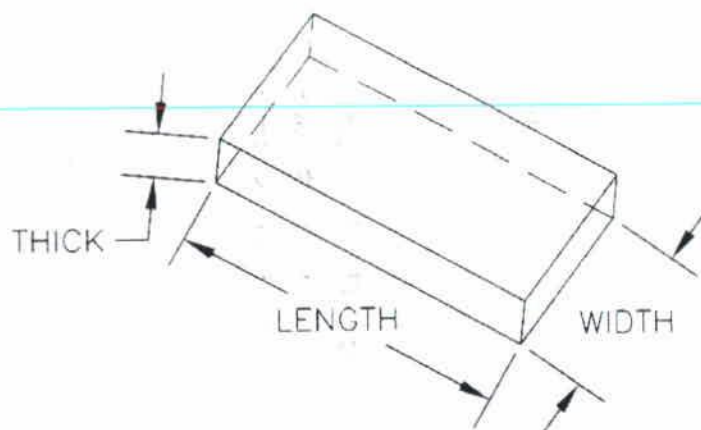
*09/10/02*



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>AS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 *A*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 46413

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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**Castle Metals®**

A. M. Castle &amp; Co.

**BORDEREAU DE MARCHANDISES**

Page 1 of 1

No de Formulaire d'Emballage / Pack Slip No:2822042

Expédié de / Ship From:		Vendu à / Sold To:		Expédié à / Ship To:		Livré à / Deliver To:	
Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date d'expédition / Date Shipped	F.O.B.	Modalités de transport / Freight Terms		Transporteur / Carrier		N° du Bon de connaissance / BOL No	N° de livraison / Delivery No
08-JUN-09	ORIGIN	Prepaid		LOCAL_FLEET		11845-10	2822042

Détails d'expédition / Shipment Details				Destination finale / Final Destination Branch - MON		
N° de commande / Order No	N° de ligne Line No	N° d'article / Item No	Description			
197018	3	6879.MO	2.5000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 8.25 IN ( ) X 10.1 IN ( )			
N° de bon de commande / Purchase Order No		Nbre de pièces / Part Number	Qté commandée / Ordered Qty	Qté Facturée / Invoice Qty	Solde à livrer / Backorder Qty	
8393			10 PCS	10 PCS		
Détails / Details						
Usine / Mill	No de coulée / Heat Number	Code méc / Mech Id	Pièces / PCS	Largeur (Pouce)/ Width (IN)	Longueur (Pouce)/ Length (IN)	Qté expédiée/ Shipped Qty (LBS)
	407251		10			210.43

Ces marchandises/technologies sont sujettes aux règlements de l'Export Administration et du département d'état des États-Unis. Si elles ont été/sont exportées, elles doivent se conformer à ces règlements. Toute modification du contrat de transport contraire aux lois des États-Unis est interdite.

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

Nous certifions par la présente que le matériel couvert par cette certification est conforme aux spécifications susmentionnées et aux exigences applicables pour le matériel, y compris toute spécification faisant partie de la description. Les rapports d'essai sont archivés pour fins de consultation. Toute requête concernant du matériel défectueux sera rejetée à moins qu'elle ne soit faite par écrit à A. M. Castle & Co. dans les 60 jours suivant la livraison. Le matériel coupé sur mesure ou coupé par le client ne peut être retourné pour crédit.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Ce matériel a été reçu et inspecté par  
This material has been received and inspected by:

Date:

# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material meet the composition limits and had the mechanical properties shown on the face of this sheet.

Per:

*Malcolm Murphy*

Malcolm Murphy  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

Ship From: RIVERDALE, IA.

993937	0				
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page
2009-01-10	3286081	00000	1000062304-1		1
P.O. No./Govt Contract No.	Customer	Alcoa Item	Mfg Order		
01-16542	CASTLE A M	G041005634R08	DS-52304-1		

Ship To: A M CASTLE & COMPANY  
3400 NORTH WOLF ROAD  
BAY #6  
FRANKLIN PARK 60131 IL

Item Description  
2.5 IN TK (+.0750 -.0750) X 48.5 IN W (+.3125 - 0.000) X 144.5 IN LN (+.5 -0.0) CAT D 164168 (M) A/T 7075-  
T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES,  
SANDWICH 6879, EXC MRK A97075-60 REV 22 AMS-QQ-A-250/12 IS 2007 AMS-  
STD-2154 EXC MRK AMS4079 REV G EXC MRK ASTM209  
REV 07 ASTM594 REV 06 BSS7055 REV A  
EXC MRK MMS159 REV N PS21211 REV K ((MARKED))  
KRAFT PAPER INTERLEAVED  
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-  
25 % US1 CL A 3 MM CQR 0137890 REV 17 CUST REQ 08-11-  
04 \*\*\* W/E 09-01-17 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	709656	407251	3545	2	PC	

Notes for CQR: 0137890.17

PRODUCT PRODUCED TO THE REQUIREMENTS OF ASTM2375 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF ASTM2375. THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12P. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12. Exception to Spec A97075-60 ; Reven: 22 Issue: Letter dated 2007-05-14 from AHERN, DENNIS T to PLATTER, BARB .

CQR: 0137890.17 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
		KSI	KSI	PCT
T7351	Long Transv.	Max	63.9	
		Min	66.0	6
T7351	Elec. Cond. (2C) & MIN	38.0 PCT		

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other	
									Each	Total	
Alloy 7075	Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
	Min			1.2		2.1	0.18	5.1			REMAIN

JAN-14-2009 10:56

AM CASTLE METALS

847458927

P.017



# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material and the composition tests and had the mechanical properties shown on the face of this sheet.

Per:

*Malcolm Murphy*

Malcolm Murphy  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

993937	0				
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page 2
2009-01-10	3286081	00000	1000062304-1		
P.O. No./Govt Contract No.	Customer	Alcoa Item	Mfg Order		
01-16542	CASTLE A M	G041005634R08	DS-62304-1		

CQR: 0137890.17 -Specification Limits (cont.)  
Lot: 407251 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	RL4D
		Test	KSI	KSI	PCT
T7351	Long Transv.	3	69.8	58.3	10.3
			69.8	58.2	10.4
			69.8	57.8	10.2

T7351 Elect Cond %IACS 40.4 40.7 40.5 PCT

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9127044	Actuals	0.06	0.29	1.6	0.02	2.5	0.19	5.7	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

CASTLE METALS CORP  
DATE RCVD 11/11/09  
IAC 6819  
APPROVED BY *(Signature)*

JAN-14-2009 10:56

AM CASTLE-METALS

8474558927

P.018

## WIP Receipt Listing

Page 1 of 1

October 1, 2009 7:21:46 AM

Criteria : Work Order ID: 46413 All Items All Product Families All References All Employees All Receipt Dates  
Grouped by Work Order ID Sorted by WO ID

Work Order ID	Reference	Item ID	Item Name	Recv. Emp.	Employee Last Name	Required Date	Required Qty	Status Code	Receiver Date	Recv. Qty	Receipt Amount	Balance Due
46413		D6101-013RevA	Saddle Billet	LACE01	Lacelle	8/03/09	50.0000	Released	8/06/09	20.0000	\$2,500.00	30.0000
Totals:							50.0000			20.0000	\$2,500.00	30.0000

# Dart Aerospace Ltd

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613) 632-3336  
Fax: (613) 632-4443

## Receiving Slip

Date Jun 10, 2009	Page 2
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Receipt Number RCP00011216
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### Purchase From:

Metaux Castle  
A.M. Castle & Co. (Canada) Inc. - Box B9204  
P.O. Box 9100  
Toronto, ON M4Y 3A5

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
BLANKET P.O			VC-MET001	PO00008393

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
		B46412 GRAIN DIRECTION ALONG 7.750" LENGTH TOLERANCE ON ALL DIMENSION ARE +0.030" / -0.000" SIZE: 7.750" X 8.250" X 2.50" THICK ALLUMINUM BILLET MATERIAL: AS ABOVE					
	D6101013P	Saddle billet	10.0000	Each	125.000000	1,250.00	Jun 10, 2009
		B46413 GRAIN DIRECTION ALONG 10.100" LEGTH TOLERANCE ON ALL DIMENSION ARE +0.030" / -0.000" SIZE: 10.100" X 8.250" X 2.50" THICK ALLUMINUM BILLET MATERIAL: AS ABOVE					

### Comments:

RELEASE DATES TBA